CLAIMS

1. A method of forming concrete articles in a vertical mould in which the concrete mix is pumped into the mould from the bottom of the mould and the segregation of the water is inhibited to maintain an homogenous viscosity as the concrete mix rises in the mould.

2. A method of forming long concrete articles in a vertical mould which includes the steps of
   a) providing a mould liner having drainage tubes to allow water to be removed from the wet concrete
   b) providing reinforcing in the mould cavity
   c) pumping wet concrete into the bottom of the mould under pressure so that the concrete rises to the top of the mould
   d) preventing water from leaving the drainage tubes during the step of filling the mould with wet concrete
   e) allowing water to drain from the drainage tubes after the mould is filled.

3. A vertical mould for forming long concrete articles having
   a) an annular mould cavity defined by a core and an outer shell
   b) a mould liner around the inner core of the mould cavity which includes vertical drainage tubes incorporating vertically space perforations to allow dewatering of the concrete
   c) means associated with said drainage tubes to prevent water leaving said drainage tubes during the filling of the mould cavity

4. A mould as claimed in claim 3 in which the drainage tubes incorporate an inner tube that is able to be pressurized to close off the perforations in the walls of the drainage tube.

5. A mould liner as claimed in claim 3 in which the drainage tubes incorporate one way valves vertically spaced apart in the drainage tube.

6. A flexible mould liner for use in the mould of claim 3 which incorporates drainage tubes to allow dewatering of the concrete wherein the drainage tubes are capable of at least partially being closed during the filling of the mould to inhibit water loss and are opened when the mould is filled.

7. A mould liner as claimed in claim 6 in which the drainage tubes incorporate an inner tube that is able to be pressurized to close off the drainage holes in the walls of the drainage tube.

8. A mould liner as claimed in claim 6 in which the drainage tubes incorporate one way valves vertically spaced apart in the drainage tube.

9. Long concrete articles formed by the process of claim 1 or 2.